ABSTRACT OF THE DISCLOSURE

A laminated entry and exit material for drilling planar sheets such as printed circuit boards having a metal foil layer bonded to a fibrous core layer with an adhesive containing a particulate lubricant such as graphite or polyethylene glycol and cold or hot pressed. A second metal layer is preferably bonded to the fibrous core layer. The core of one embodiment of the exit material includes a particulate lubricant such as graphite or polyethylene glycol incorporated in the core at the time of manufacture of the core. The circuit board is placed between the entry and exit materials. Drill friction and heat are reduced by the lubricants and the heat sink provided by the foil thereby extending the service life of a drill.